

Date: Tuesday, 01/04/2008 3:15:59 PM  
User: Jean-Luc Menard

# **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHAFT SLEEVE
Job Number : 37648	
Estimate Number : 11155	
P.O. Number :	Part Number : D32337
This Issue : 01/04/2008 S.O. No. :	Drawing Number : D3233 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 26/02/2008 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35400	Material :
Written By : <u>Jan 08.04.01</u>	Due Date : 22/03/2008 Qty: <u>28</u> Um: Each
Checked & Approved By :	
Comment : Est. A 08.03.14 New issue KJ/JLM	

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1020TR1375W125	COLD DRAWN ROUND TUBE
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Comment: Qty.: 0.1860 f(s)/Unit Total : 2.2315 f(s)  
1020-1025 Round Tube  
Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020  
SRA or AMS 5075 or AMS 5077  
(M1020TR1.375W.125)  
Identify for D3233-7  
Batch: 1107934 20 08/05/22

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA735 Rev. B & Dwg D3233 Rev. B

2-Deburr per dwg D3233 20 08/05/22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE 20 08/05/22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK Jan 08.05.22

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHAFT SLEEVE

Job Number: 37648

Part Number: D32337

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W522

*PL 08-05-27*

*(X22)*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



*18/05/27 JF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

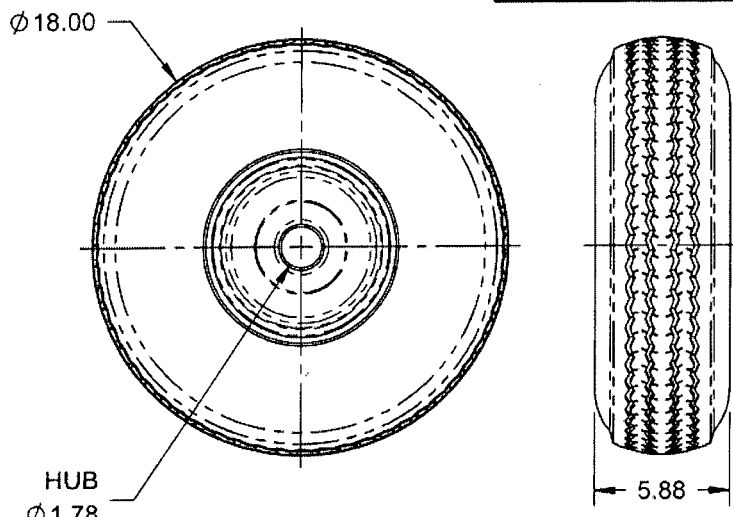


*MF 08-05-27*





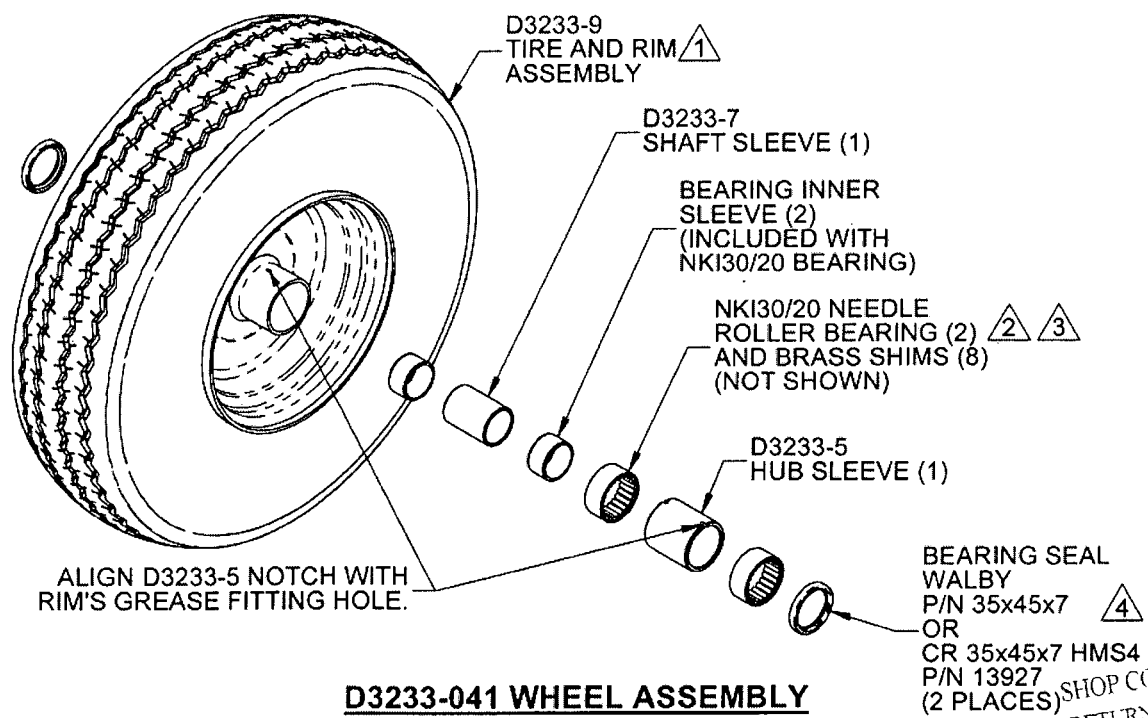
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CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE	05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED  
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



### D3233-041 WHEEL ASSEMBLY

#### NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH  
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

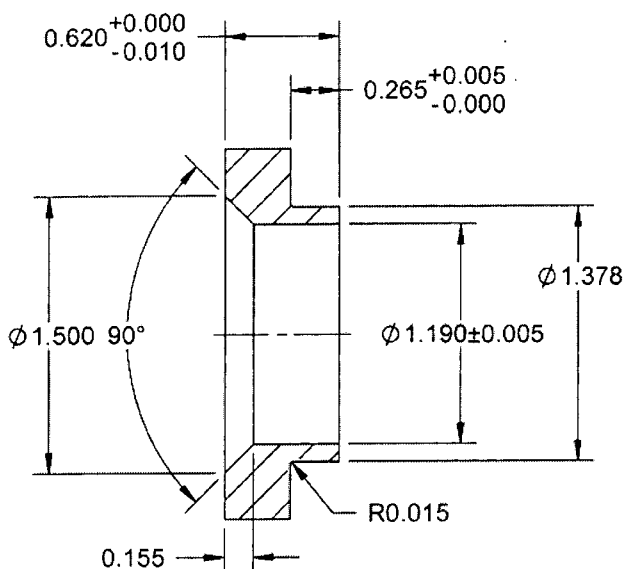
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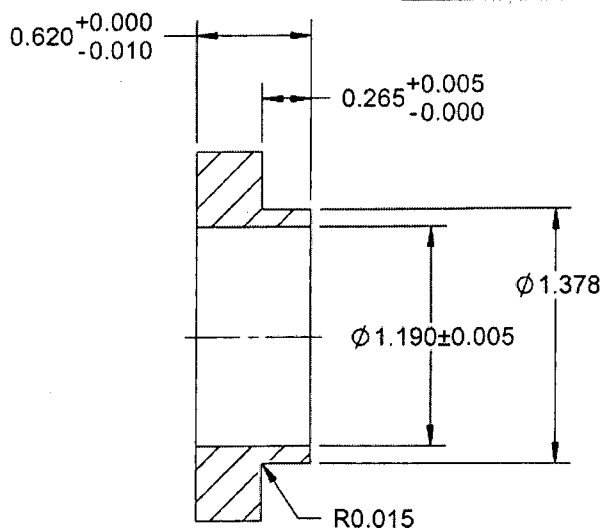
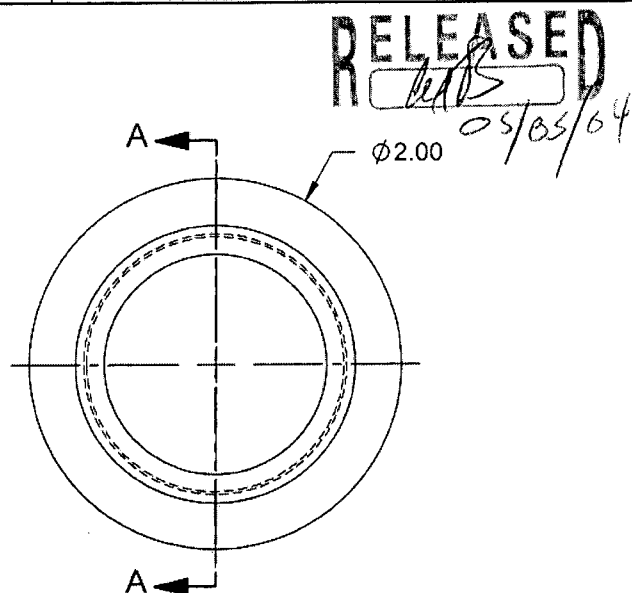


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DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1



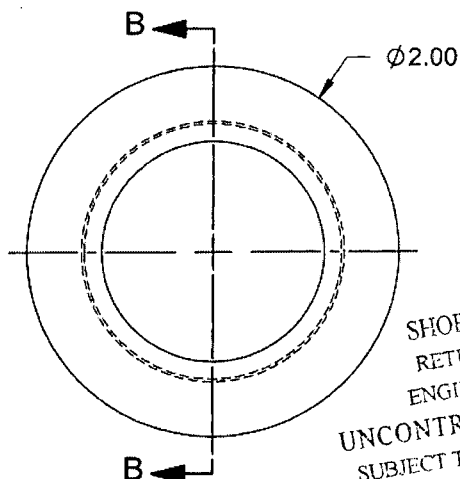
**SECTION A-A**

**D3233-1 INSIDE WASHER**



**SECTION B-B**

**D3233-3 OUTSIDE WASHER**



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**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

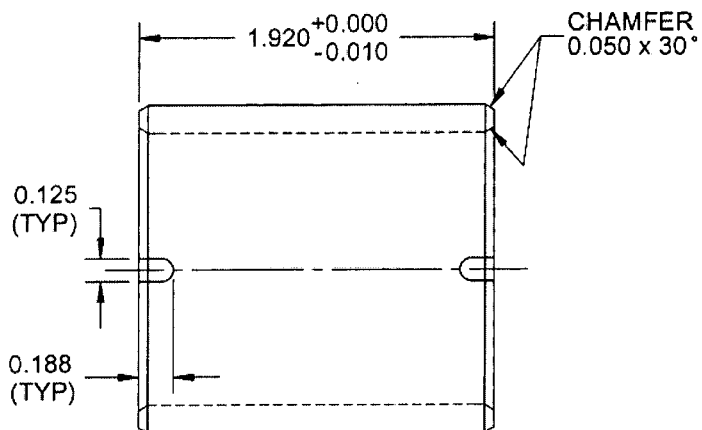
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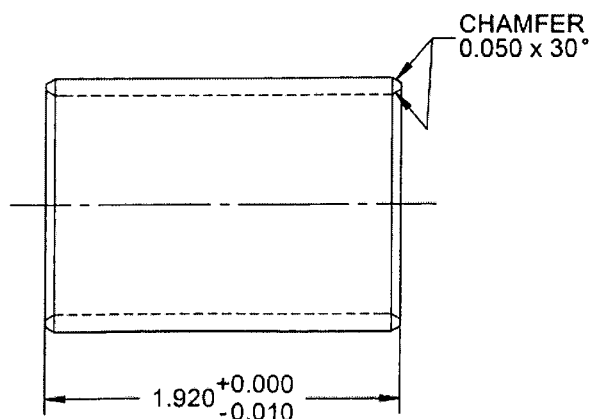
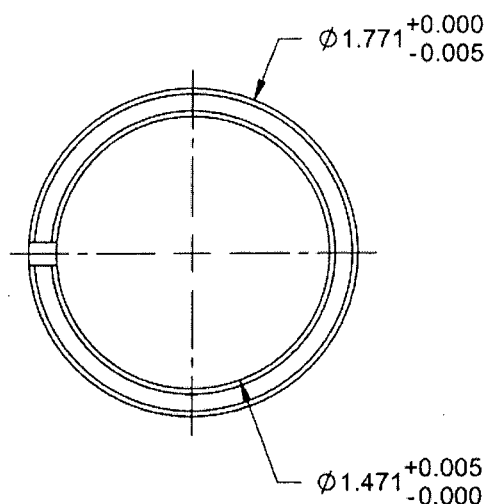


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. B SHEET 3 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1

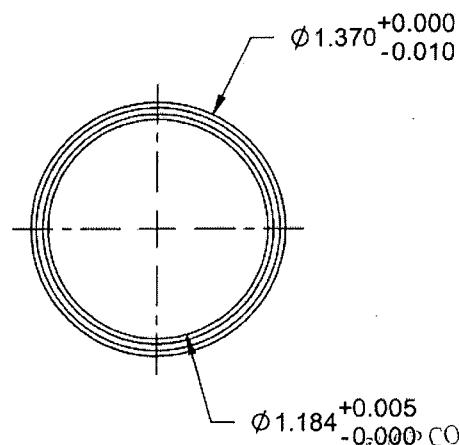
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05/05/04



**D3233-5 HUB SLEEVE**



**D3233-7 SHAFT SLEEVE**



**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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WORK ORDER NO. **37648**

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